

Work Order ID 50090

Page 1

July 08, 2009 9:28:25 AM

Item ID: D2362-3 Accept Setup Start
Revision ID: E1 Stop
Item Name: Support Bracket
Start Date: 7/10/2009 Start Qty: 6.00 Cust Item ID:
Required Date: 7/31/2009 Req'd Qty: 6.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2362	Rev E1								

100

0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

A A

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E ☐ 2-Deburr
per dwg D2362J.L.
09/07/11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

J.L.
09/07/11

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

J.F.
09/07/11

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50090

Page 2

July 08, 2009 9:28:25 AM

Item ID: D2362-3 Accept Setup Start
 Revision ID: E1 Stop
 Item Name: Support Bracket
 Start Date: 7/10/2009 Start Qty: 6.00 Cust Item ID:
 Required Date: 7/31/2009 Req'd Qty: 6.00 Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:00 AM OVEN TEMPERATURE: 9:30 AM FINISH TIME: 3:20 PM								
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

u/45

09-07-13

09-07-13 112148 09-07-13 6

BL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July 08, 2009 9:28:25 AM

Page 3

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Bond rubber D2397-1 followed by D2397-3 using contact cement ☐ as per Dwg
D2362 Batch *M109109*

Batch *M109109*

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:_____

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50090

Page 4

July 08, 2009 9:28:25 AM

Item ID: D2362-3 **Accept** **Setup** **Start**
Revision ID: E1 **Stop**
Item Name: Support Bracket
Start Date: 7/10/2009 **Start Qty:** 6.00 **Cust Item ID:**
Required Date: 7/31/2009 **Req'd Qty:** 6.00 **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start**
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/16 HJ

mf 09-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 08, 2009 9:28:25 AM

Work Order ID: 50090

Parent Item: D2362-3RevE1

Parent Item Name: Support Bracket

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2397-3RevC		Manufactured	No			100	Each	18.0000	6.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Rubber Cushion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

18

38054

18

D2265RevA		Manufactured	No			160	Each	142.0000	6.0000			
-----------	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

Step Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

142

37477

42

44114

100

D2397-1RevC		Manufactured	No			160	Each	19.0000	6.0000			
-------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Rubber Cushion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

19

38053

19

<u>6</u>	EB09/07/13
----------	------------

<u>6</u>	DIT 09/07/09
----------	--------------

<u>6</u>	EP09/07/13
----------	------------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE		TITLE
98.12.04		STEP SUPPORT BRACKET
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

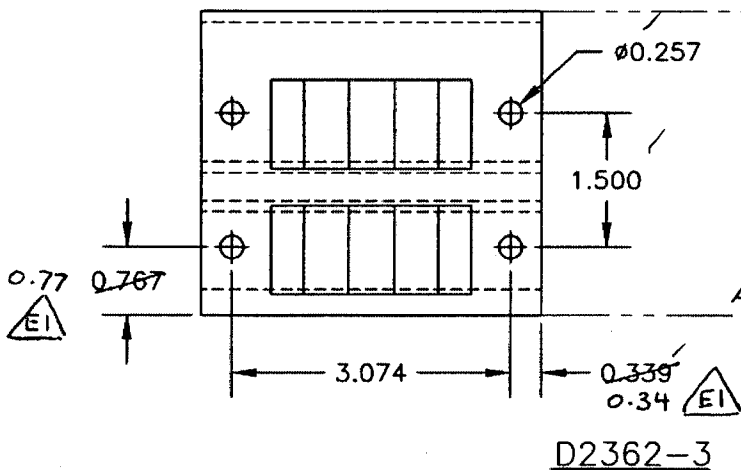
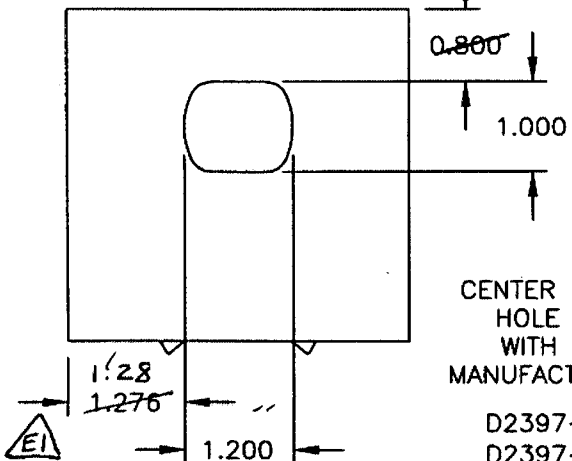
98.03.15 CP

DESIGN OK, BUT CHECK WITH
3B BEFORE MANUFACTURE
OK 07/11/09

0.257 X 0.75 SLOT

REMOVE TIPS
FROM CASTING
MAX 0.080CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATIOND2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A

**NOTES:**

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAMKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED CP	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 2 OF 3

RELEASED
98.12.14 KE
UNDER REVIEW

CHUS, DS CP

DESIGNER, SUP CHECK BY
JTB BEING MANUFACTURED
OK CP 08.1.09MACHINE TO
R1.100
(TYP 2 PLACES)REMOVE TIPS
FROM CASTING
MAX 0.080

0.257 X 0.75 SLOT

VIEW A-A

1.500 1.50

1.876
1.88

Ø0.257 0.100

R16.680

1.500

0.77 0.767

3.074

0.339

BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5D2362-1 & D2362-5**NOTES:**

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY


NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

3.750 (REF)

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004 

UNDER REVIEW

010315 CP
DESIGN OK, BUT CHECK WITH
JTB BEFORE MANUFACTURE

98.12.14 KE

Dr. J. S. H. H. H.

- D2362-7

Technical drawing of a rectangular plate with dimensions and hole locations. The plate has a width of 3.074 and a height of 1.500. There are two rows of holes, each containing five holes. The distance between the centerlines of the two rows is 0.767. The distance from the top edge to the centerline of the top row of holes is 0.257. The distance from the bottom edge to the centerline of the bottom row of holes is 0.34. The distance from the right edge to the centerline of the rightmost hole in the bottom row is 0.339. A triangle with the letter 'E' is located at the bottom right corner.

DART

QA CONTROLLED

DESIGN	DRAWING NO.		REV. E
BW	HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 3
KE	##	D2362	
DATE	TITLE		SCALE
98.12.04	STEP SUPPORT BRACKET		1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries